Work Order ID 65899

Quality Control

Thursday, January 27, 2011 7:18:49 AM

Item ID: D3477-1 Accept Setup Start **Revision ID:** Stop Flange Item Name: **Start Date:** 1/27/2011 Start Qty: 2.00 **Cust Item ID:** Required Date: 2/1/2011 **Req'd Qty: 2.00 Customer:** Reference: Start Run Tooling: **Process Plan: Approvals:** Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Tool ID Set Up/ Tool # Plan Accept Reject Reject Insp. Work Center ID Description Run Hours Code Qty Qty Number Stamp Draw Nbr **Revision Nbr** Rev B D3477 100 0.00 FLOW WATER JET 10-11-17 Waterjet 0.00 Memo FLOW CNC Waterjet Cut as per Dwg D3477 Dwg Rev: Prog Rev: 110 QC2- Inspect parts off machine FAI/FAIB 0.00 1011-1-37 QC 0.00 Memo Quality Control 120 QC8- Inspect parts - second check 0.00 Sulvilaz QC Memo

Dart Aerospace	Ltd
----------------	-----

										. •		
W/O:		WORK ORDER CHANGES										
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	C	ate	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
								,				
							•					
							·					
Part No	:	PAR #:	Fault Cate	gory:	NCR: Y	es No	DQA	٨:	_ Date: _			
Re		esolution:	Disposition	n:	QA: N/C	Close	ed:		Date: _			
NCR:			WORK ORD	ER NON-CONFORM	MANCE (N	CR)						
DATE	OTED	Description of NC		ection B		Verification		Approval	Approval			
DATE	STEP Description of NC Section A		Initial Chief Eng	Action Description Chief Eng		n & ate	Section	on C	Chief Eng	QC Inspector		
· · · · · ·												
							····					
				1 •								
						-						

Work Order ID 65899 Thursday, January 27, 2011 7:18:50 AM Item ID: D3477-1 Accept Setup Start **Revision ID:** Stop Item Name: Flange Start Qty: 2.00 **Start Date:** 1/27/2011 **Cust Item ID:** Required Date: 2/1/2011 **Req'd Qty: 2.00 Customer:** Reference: Start Run Date: Approvals: Process Plan: Tooling: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID Description Qty Number **Run Hours** Code Otv Stamp 130 0.00 Small Fab Small Fab 0.00 Memo Small Fab 1-Deburr if necessary. 2-Form as per Dwg D3477 using Dt8858 A,B&C 140 QC5- Inspect part completeness to step on W/O QC Memo Quality Control

150

Identify as per dwg & Stock Location: 100 0.00

Packaging

Memo

0.00

Packaging

	- CP - C									į,			
W/O:			W	ORK ORDER CHAN	IGES								
DATE	STEP	PRO	PROCEDURE CHANGE					Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
Part No):	PAR #:	Fault Cate	egory:	NCR:	Yes N	o DQ	A:	Date: _				
Re		esolution:	Disposition	on:	QA: N/C Closed: Date: _								
NCR:		WORK ORDER NON-CONFORMANCE (NCR) Corrective Action Section B											
DATE		Description of NC		Section B		Verific	cation	Approval	Approval				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Sect	on C	Chief Eng	QC Inspector			
							1						
				,						•			
	İ												
									!				
							1						

e forfer en en energie de l'encolor

Work Order ID 65899

Thursday, January 27, 2011 7:18:50 AM

Memo

inursaay, Janu	ary 27, 2011	7.16.30 AIM										
Item ID:	D3477-1			Accept				S	Setup S	Start		
Revision ID:									•			
Item Name:	Flange								,	Stop		
Start Date:	1/27/2011	Start Qty: 2.00			Cust Item I	D:						
Required Date	: 2/1/2011	Req'd Qty: 2.00			Customer:							
Reference:												
Approvals:	Process Plan:		Date:	Tooling:	Date:			R	Run S	Start		
	QC:		Date:	SPC (Y/N):	D	ate:			;	Stop		
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept	Rejec	et Reject Number	Insp.	
160	D	QC21- Final Inspection	- Work Order Release	0.00			Code	Qty	Qty	Number	Stamp	

0.00

Quality Control

QC

11/01/31 Af PM11-01-28

										,	
W/O:		WORK ORDER CHANGES									
DATE	STEP	PRO	PROCEDURE CHANGE					Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
							,				
								:			
Part No	:	PAR #:	Fault Cate	jory:	NCF	R: Yes	No DQ	A:	Date: _		
	R	esolution:	Disposition	n:	QA:	N/C Cld	sed:		Date:		
NCR:			WORK ORDE	R NON-CONFORM	IANCE	(NCR)				
DATE	STEP	Description of NC	Corrective Action Section B			Sign & Verificatio			Approval	Approval	
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng		Date	Sect	ion C	Chief Eng	QC Inspector	
		·									
					•						
									}		
-											
								-1			
						į					

Picklist Print

· Thursday, January 27, 2011 7:18:47 AM

Work Order ID: 65899

Parent Item:

D3477-1

Parent Item Name: Flange

Start Date: 1/27/2011

Required Date: 2/1/2011

Page 1

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev:A

New Issue 06-02-07 JLM

· ·													
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S26GA		Purchased	No			100	sf	52.8100	0.37	0.74	<u></u>	-	
304/316 0 018 SHEET						•					BILIT	7	

304/316 0.018 SHEET

Location	Loc Qty	Loc Code	
MAT20	52.81		
109398	20.06		
112885	32.75		117865



Dail Aci	oopuoc	LIM							,				
W/O:			WO	RK ORDER CHANG	ES				•				
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Da	te Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
				•									
Part No	:	PAR #:	Fault Categ	gory:	_ NCR: Ye	s No	DQA:	Date: _					
Re		esolution:	Disposition	1:	_ QA: N/C	Closed	l:	Date: _					
NCR:			WORK ORDER NON-CONFORMANCE (NCR)										
DATE	STEP	Description of NC			Section B Ve				Approval				
	O.E.	Section A	Initial Chief Eng	Action Description Chief Eng	Di	ite	Section C	Chief Eng	QC Inspector				
	,	·											

DART AEROSPACE LTD	Work Order: 65899
Description: Flance	Part Number: D3477-1
Inspection Dwg: D3477 - (, Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

	Drawing imension	Tolerance	Actual Dimension	Accept	Rejest	Method of Inspection	Comments
Ø	(193	1005-001	,195	~		U BUZ	
\$	3.40	4-,036	3,402	Y		V	
Ø	6.560	+ .010	6,561	7		V	
d	7.3	+/030	7.125	50		V	
7	810,	4010	1019	9		V	·
					<u> </u>		
				<u> </u>			
					ļ		
		-			<u> </u>		
							· .
ļ					-		·
					 		
						-	
				1.	_		
					<u> </u>	-	

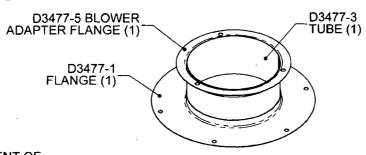
Measured by: 43	Audited by:	Prototype Approval:	
Date: (1 - (- 57	Date: 11/01/07	Date:	

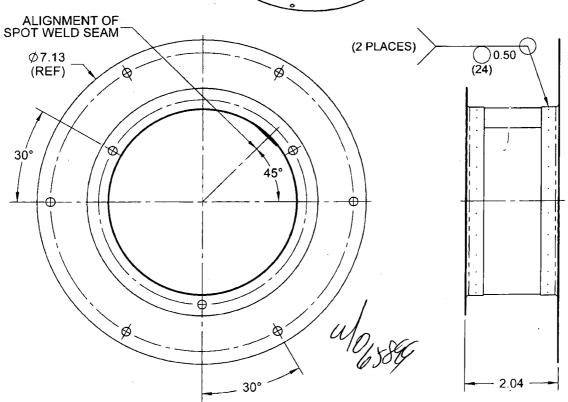
1		D-4	Obanas	Revised by A	pproved
	Rev	Date *	Change		
	Α		New Issue	KJ/JLM KJ/JLM	



		ı	1 _				
DESIGN		4	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
	CHECKED		APPROYED	DRAWING NO.	REV. B		
			THE THE	D3477 SHE	EET 1 OF 4		
	DATE			TITLE -	SCALE		
	08.12.19			BLOWER INLET ADAPTER	1:2		
	Α	0:	5.12.09	NEW ISSUE			
	B 08.12.19		8.12.19	ϕ 3.40 & ϕ 4.1 WERE ϕ 3.600 & ϕ 4.14 (SHT 2 & 4); ADD MFG NOTE AND TOL (SHT 3); MATL SPEC WAS MIL S-5019			







D3477-041 BLOWER MOTOR INLET ADAPTER

NOTES:

- 1) SPOT WELD PER DART QSI 004 2) FINISH: NONE
- 1) SPOT WELD PER DART QSI 004
 2) FINISH: NONE
 3) IDENTIFY WITH DART P/N D3477-041 USING
 FINE POINT PERMANENT INK MARKER
 4) TOLERANCES ARE PER DART QSI 018 UNLESS
 OTHERWISE NOTED
 5) ALL DIMENSIONS ARE IN INCHES
 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION BLOWER MOTOR ASSEMBLY			
X	D3477-041				
1	D3477-1	FLANGE			
1	D3477-3	TUBE			
1	D3477-5	BLOWER ADAPTER FLANGE			

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

W/O:			W	ORK ORDER CHANG	ES					
DATE STEP		PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	}									
								<u> </u>		
				*						
					·					
Part No	•	PAR #:	Fault Cate	gory:	_ NCR	l: Yes N	lo DQ	A:	Date:	
	R	esolution:	ion: Disposition:			N/C Clo	sed:	······································	Date:	
NCR:	·		WORK ORD	ER NON-CONFORMA	ANCE	(NCR)	ı			
DATE	STEP	Description of NC			ion B	0: 0	Verific	cation	Approval	Approval
DAIL	O I E I	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti	ion C	Chief Eng	QC Inspector
		·								·
•										
	-									
								<u> </u>		



DESIGN	DRAWN BY	DART AEROSPACE LTD				
		HAWKESBURY ONTARIO, CANADA	·			
CHECKED	APPROYED	DRAWING NO.	REV. B			
PH	THE THE	D3477	HEET 2 OF 4			
DATE		TITLE	SCALE			
08.1	12.19	BLOWER INLET ADAPTER	1:2			
		DELEASEN				
galo M						

D3477-1 FLANGE

Ø0.193 0.39 Ø7.13 -(6 PLACES) \emptyset 6.560 -R0.06 B Ø 4.1 60° (TYP) Ø3.40 B

NOTES:

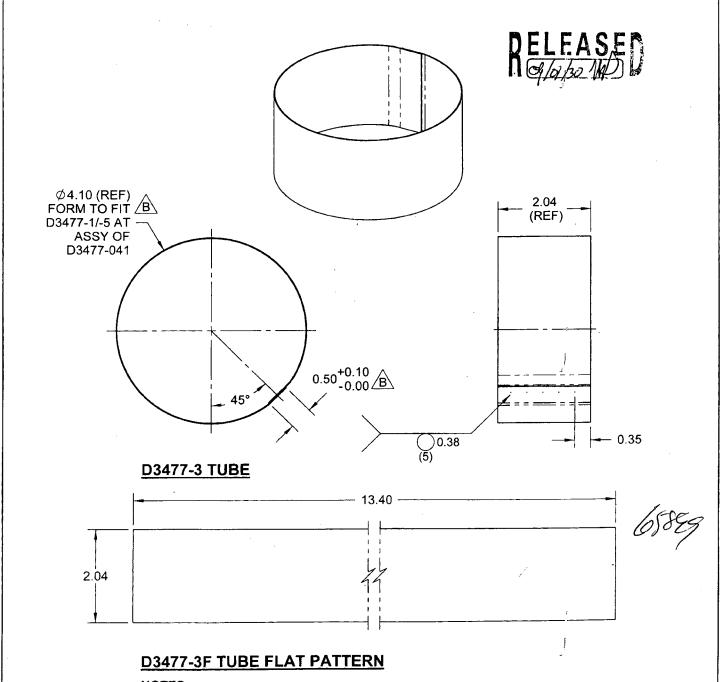
- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 3) ALL DIMENSIONS ARE IN INCHES 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

D3477-1F FLANGE FLAT PATTERN

COPYRIGHT © 2005 BY DART AEROSPACE LTD.



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
CHECKED	APPROVED	DRAWING NO. D3477	REV. B		
DATE 08.12.19		BLOWER INLET ADAPTER	SCALE 1:2		



NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
 2) WELD PER DART QSI 004
 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) ALL DIMENSIONS ARE IN INCHES
 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

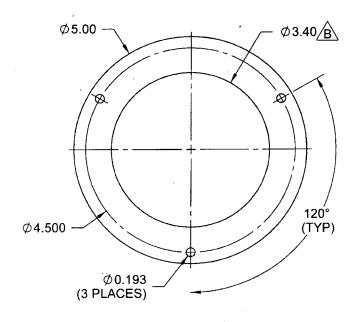
COPYRIGHT © 2005 BY DART AEROSPACE LTD.

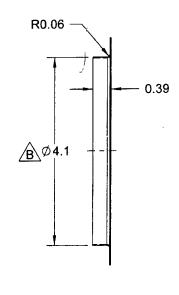
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
CHECKED	APPROVED	D3477 sh	REV. B EET 4 OF 4		
DATE 08.	.12.19	BLOWER INLET ADAPTER	SCALE 1:2		

RELEASED





D3477-5F FLAT PATTERN

D3477-5 BLOWER

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
 3) ALL DIMENSIONS ARE IN INCHES
 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

COPYRIGHT © 2005 BY DART AEROSPACE LTD.